

5/20

SPUR

(4)

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23022
<b>Description:</b> Wheel Shaft	<b>Part Number:</b>	D3334-1
<b>Dwg:</b> D3334 Rev. A	<b>Qty:</b>	24
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HJ	05.04.13	24
2	MS	Cut blanks: Ø3.500" Bar to 7.750" long Material: AISI 4140 or ASTM A304-02/A-434-BC/A193-03-Grade-B7/A29-03/A322-91 or UNS# G41400 (M4140H-R3.500) <b>Identify for D3334-1</b> Batch: 116808	gml	05/06/16	4
3	MS	Turn as per Folio FA492 and Dwg D3334	gml	05/06/16	4
4	QC2	Inspect parts as they come off the CNC machine	gml	05/06/16	4
5	MS	Deburr	gml	05/06/16	4
6	MV	Machine as per Folio FA492 and Dwg D3334 <b>Identify as D3334-1</b>	gml	05.06.16	4
7	QC2	Inspect parts as they come off the CNC machine	gml	05.06.16	4
8	QC8	Second check	gml	05.06.16	4
9	QC5	Inspect work to step 8	gml	05.06.17	4
10	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 <b>Mask thread and bearing surface</b>	gml	05.06.17	4
11	QC3	Inspect Powder Coat	gml	05.06.17	4
12	ST	Identify and Stock	CPL	05/06/17	4
13	AC	Cost / part: 21.66	AB	05/06/17	4
14	DC	Close W/O 67.07 Inspect Level 21	HJ	05.06.27	4

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	
B	05.03.02	Revised material; Added Powder Coat	KJ/JLM	

RELEASED  
05.03.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

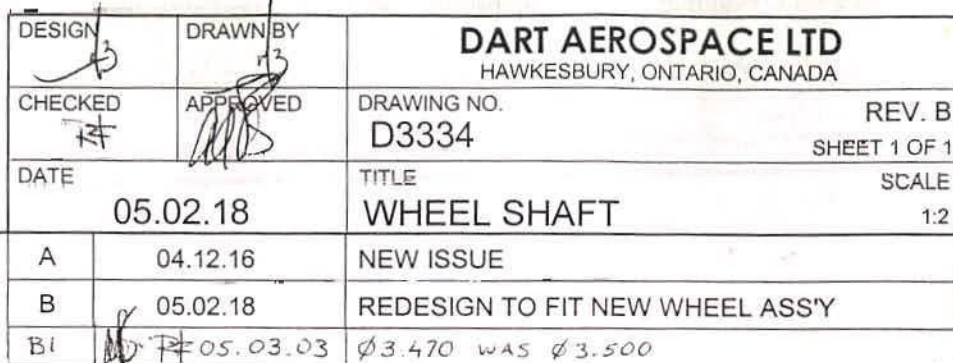
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

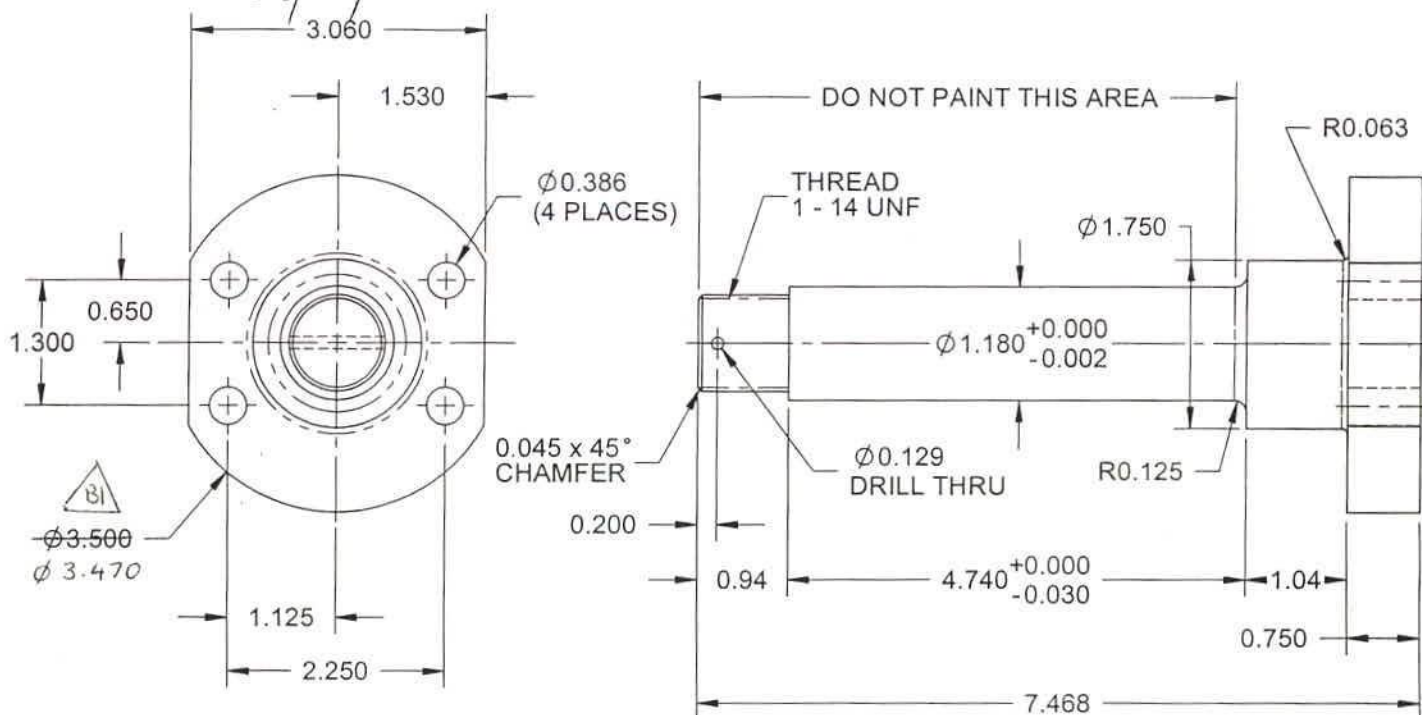
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_





RELEASED

05/02/22



NOTES:

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03-GRADE-B7/ A29-03/ A322-91  
OR UNS#-G41400 (REF. DART SPEC. M4140H-R3.500)
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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RETURN TO  
ENGINEERING

UNCONTROLLED COPY

A29-03/ A322-91

4.3  
WORK ORDER

NO. 23022

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Apr 12, 2005  
02:25 pm

Work Order No : 0023022  
Project Name : D3334-1  
Project For : WK520  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3334-1  
Description : Wheel Shaft  
Manufactured : Yes  
Amount Req'd : 24  
Amount Done : 0  
Start Date : 04-12-05  
Est Finish Date : 05-15-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



DART AEROSPACE LTD		Work Order: 23022
Description: Wheel Shaft		Part Number: D3334-1
Inspection Dwg: D3334 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 3.470	±.010	Ø 3.473	—		Vern	
1.300	±.005	1.297	✓			
3.060	±.010	3.055	✓			
Ø 0.386	±.005 ±.000	Ø .388	✓			
2.250	±.005	2.247	✓			
0.200	±.010	.203	✓			
0.94	±.030	0.940	✓		Vern	
4.740	±.030 ±.000	4.740	✓		Vern	
1.04	±.030	1.038	✓		Vern	
0.750	±.010	0.750	✓		Vern	
7.468	±.010	7.467	✓			
Ø 0.129	±.003 ±.000	Ø .129	✓			
R 0.125	±.010	R 0.125	✓		R-G	
Ø 1.180	±.000 ±.002	Ø 0.179	✓		Micro	
Ø 1.750	±.010	1.745	✓		Micro	
R 0.063	±.010	R 0.063	✓		R-G	

Measured by: <i>Jrf</i>	Audited by: <i>[Signature]</i>	Prototype Approval:
Date: 05/06/16	Date: 05/06/16	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	